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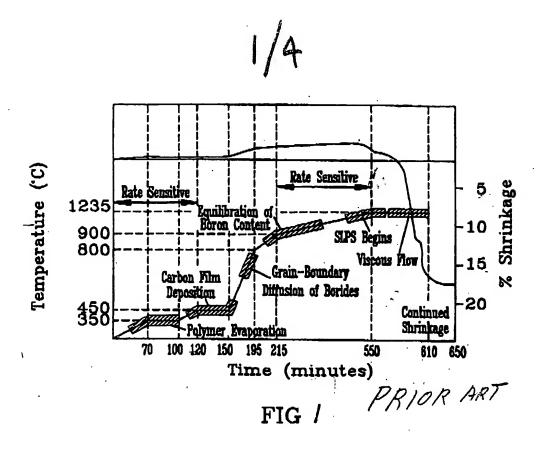
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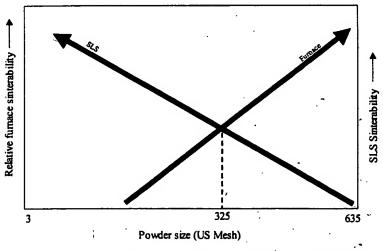


Figure 2 Powder size vs SLS and furnace sinterability

	Metal powder size distribution		Metal and binder powders blend			
	Total wt %	Size micron	Non Borided wt %	Borided wt %	Nylon 12 wt %	BMI wt %
Original	55 \ 45	-88 to +44 -44	90	10	3	0.5
New	100	-44	85	157.	0.5	0.5

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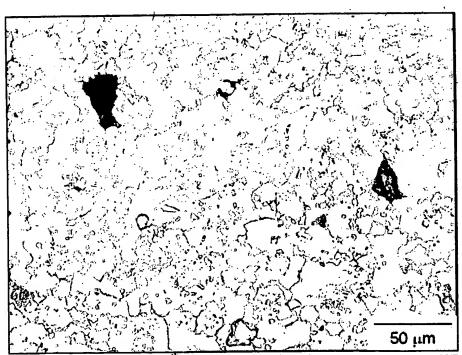
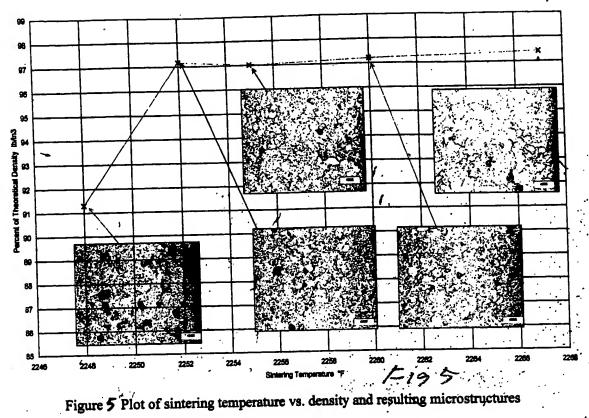


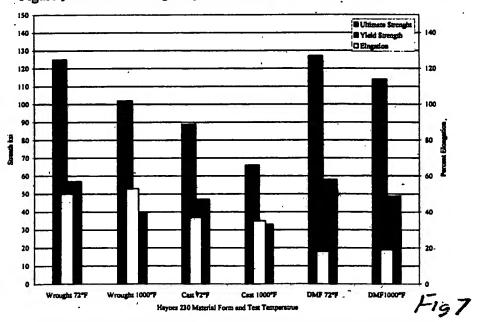
Figure 4 Sample 215-3, 6th sintering run, sintering temperature 2255°F, etched, optical, bright field image, ~400x

Parameters/Trial	6		
Material (%-% by wt.)	Alloy230+B (85-15)		
Binder (% by wt.)	0.5% N-12		
BMI (% by wt.)	0.5% BMI		
Powder Distribution (μm)	-44		
Debind Cycle			
Ramp Rate (°F/min)	2 =		
Hold Temp (°F)	1652		
Hold Time (min)	15		
Pressure (torr)	700		
Gas	Ar		
Sinter Cycle			
Ramp Rate (°F/min)	.1		
Hold Temp (°F)	2255 /		
Hold Time (min)	10		
Pressure (torr)	300		
Gas	5%H2-95%Ar		

Fig 6







. Comparison of DMF Alloy 230, cast and wrought Haynes 230 properties